

CX500-HBPN

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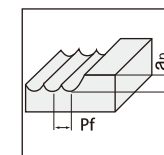
- 长颈立铣刀 Long Neck
- 平头立铣刀 Square
- 圆弧角立铣刀 Radius
- 球头立铣刀 Ball
- 长颈立铣刀 Long Neck
- 粗铣刀 Roughing
- 倒角加工用立铣刀 Chamfering
- 钻头 Drill

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MODEL 型号	R	/ 刃长	/ 1	θ1	/ 2	D1	L 全长	d 柄径			
CX500-HBPN2-0.3-0.5-4	0.3	0.45	1.2	0.5°	4	0.65	50	4			
CX500-HBPN2-0.3-0.5-6					6	0.69					
CX500-HBPN2-0.3-0.5-8					8	0.72					
CX500-HBPN2-0.3-0.5-10					10	0.76					
CX500-HBPN2-0.3-1-4				0.3	0.45	1.2			1°	4	0.7
CX500-HBPN2-0.3-1-6										6	0.77
CX500-HBPN2-0.3-1-8									8	0.84	
CX500-HBPN2-0.3-1-5-6									6	0.86	
CX500-HBPN2-0.3-1-5-8									8	0.96	
CX500-HBPN2-0.3-2-6									6	0.94	
CX500-HBPN2-0.3-2-8	8	1.08									
CX500-HBPN2-0.3-3-6	6	1.11									
CX500-HBPN2-0.3-3-8	8	1.32									
CX500-HBPN2-0.3-5-8	8	1.79									
CX500-HBPN2-0.4-0.5-8	0.4	0.6	1.6	0.5°	8	0.92					
CX500-HBPN2-0.4-0.5-10					10	0.95					
CX500-HBPN2-0.4-1-8				8	1.03						
CX500-HBPN2-0.4-1-10				10	1.1						
CX500-HBPN2-0.4-1.5-8				8	1.14						
CX500-HBPN2-0.4-1.5-10				10	1.24						
CX500-HBPN2-0.4-2-10				10	1.39						
CX500-HBPN2-0.4-3-10				10	1.69						
CX500-HBPN2-0.5-0.5-10				0.5	0.75	2	0.5°	10	1.14		
CX500-HBPN2-0.5-0.5-15								15	1.23		
CX500-HBPN2-0.5-0.5-20	20	1.32									
CX500-HBPN2-0.5-1-5	5	1.11									
CX500-HBPN2-0.5-1-10	10	1.28									
CX500-HBPN2-0.5-1-15	15	1.46									
CX500-HBPN2-0.5-1-20	20	1.63									
CX500-HBPN2-0.5-1-25	25	1.18									
CX500-HBPN2-0.5-1.5-5	5	1.16									
CX500-HBPN2-0.5-1.5-10	10	1.42									
CX500-HBPN2-0.5-1.5-15	15	1.69									
CX500-HBPN2-0.5-1.5-20	20	1.95									
CX500-HBPN2-0.5-2-15	15	1.91									
CX500-HBPN2-0.5-2-20	20	2.26									
CX500-HBPN2-0.5-3-15	15	2.37									
CX500-HBPN2-0.5-3-20	20	2.89									
CX500-HBPN2-0.5-5-25	25	5.03									
CX500-HBPN2-0.6-0.5-15	0.6	0.9	2.4	0.5°	15	1.42					
CX500-HBPN2-0.6-0.5-20					20	1.51					
CX500-HBPN2-0.6-1-10				10	1.47						
CX500-HBPN2-0.6-1-20				20	1.82						
CX500-HBPN2-0.6-1.5-10				10	1.6						
CX500-HBPN2-0.6-1.5-20				20	2.13						
CX500-HBPN2-0.6-2-10				10	1.74						
CX500-HBPN2-0.6-2-20				20	2.43						
CX500-HBPN2-0.6-3-15				15	2.53						
CX500-HBPN2-0.6-5-15				15	3.41						
CX500-HBPN2-0.75-0.5-10	0.75	1.1	3	0.5°	10	1.63					
CX500-HBPN2-0.75-0.5-15					15	1.71					
CX500-HBPN2-0.75-0.5-20				20	1.8						
CX500-HBPN2-0.75-1-10				10	1.75						
CX500-HBPN2-0.75-1-15				15	1.92						
CX500-HBPN2-0.75-1-20				20	2.1						
CX500-HBPN2-0.75-1.5-10				10	1.87						
CX500-HBPN2-0.75-1.5-15				15	2.13						
CX500-HBPN2-0.75-1.5-20				20	2.39						
CX500-HBPN2-0.75-2-10				10	1.99						
CX500-HBPN2-0.75-2-15	15	2.34									
CX500-HBPN2-0.75-2-20	20	2.69									
CX500-HBPN2-0.75-3-20	20	3.39									
CX500-HBPN2-0.75-3-15	15	2.76									
CX500-HBPN2-0.75-3-20	20	3.29									
CX500-HBPN2-0.75-5-15	15	3.6									
CX500-HBPN2-1-0.5-15	1	1.5	4	0.5°	15	2.20					
CX500-HBPN2-1-0.5-20					20	2.28					
CX500-HBPN2-1-0.5-30				30	2.46						
CX500-HBPN2-1-0.5-40				40	2.63						
CX500-HBPN2-1-0.5-50				50	2.81						
CX500-HBPN2-1-1-15				15	2.39						
CX500-HBPN2-1-1-20				20	2.56						
CX500-HBPN2-1-1-25				25	2.74						
CX500-HBPN2-1-1-30				30	2.91						
CX500-HBPN2-1-1-35				35	3.09						
CX500-HBPN2-1-1-40	40	3.26									
CX500-HBPN2-1-1-50	50	3.61									

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CX500-HBPN2-1-1.5-15	1	1.5	4	1.5°	15	2.58	50	6			
CX500-HBPN2-1-1.5-20					20	2.84					
CX500-HBPN2-1-1.5-25					25	3.10					
CX500-HBPN2-1-1.5-30					30	3.37					
CX500-HBPN2-1-1.5-40					40	3.89					
CX500-HBPN2-1-1.5-50				50	4.41						
CX500-HBPN2-1-2-30				1	1.5	4	2°	30	3.82	70	6
CX500-HBPN2-1-2-40								40	4.52		
CX500-HBPN2-1-3-30							30	4.73	70	110	
CX500-HBPN2-1-3-40							40	5.78			
CX500-HBPN2-1.5-0.5-20	1.5	2.5	6				0.5°	20	3.25	70	6
CX500-HBPN2-1.5-0.5-30								30	3.42		
CX500-HBPN2-1.5-0.5-40								40	3.6		
CX500-HBPN2-1.5-0.5-50								50	3.77		
CX500-HBPN2-1.5-1-20								20	3.49		
CX500-HBPN2-1.5-1-30							30	3.84			
CX500-HBPN2-1.5-1-40				40	4.19	110	6				
CX500-HBPN2-1.5-1-50				50	4.54						
CX500-HBPN2-1.5-1.5-20				1.5	2.5	6	1.5°	20	3.74	70	6
CX500-HBPN2-1.5-1.5-30								30	4.26		
CX500-HBPN2-1.5-1.5-40	40	4.79	110				6				
CX500-HBPN2-1.5-1.5-50	50	5.31									
CX500-HBPN2-1.5-2-40	1.5	2.5	6				2°	40	5.38	110	6
CX500-HBPN2-1.5-2-48								48	5.94		
CX500-HBPN2-1.5-3-34								34	5.94		
CX500-HBPN2-2-0.5-40								40	4.56		
CX500-HBPN2-2-0.5-50								50	4.47		
CX500-HBPN2-2-0.5-60							60	4.91			
CX500-HBPN2-2-1-40				40	5.12	110	6				
CX500-HBPN2-2-1-50				50	5.47						
CX500-HBPN2-2-1-60				60	5.82						
CX500-HBPN2-2-1.5-40				2	3	8	1.5°	40	5.68	110	6
CX500-HBPN2-2-1.5-46	46	6.00									
CX500-HBPN2-2-3-27	27	6.00									
CX500-HBPN2-3-1-40	40	6.98									
CX500-HBPN2-3-1-50	50	7.33									
CX500-HBPN2-3-1-60	60	7.68	110				8				
CX500-HBPN2-3-1.5-40	40	7.47									
CX500-HBPN2-3-1.5-50	50	8.00									
CX500-HBPN2-3-3-31	3	6	12				1.5°	50	8.00	110	8
CX500-HBPN2-3-3-31								31	8.00		
CX500-HBPN2-5-1.5-54				54	12.00						
CX500-HBPN2-5-2-44				44	11.96						
CX500-HBPN2-5-3-35				35	12.00						

推荐切削条件 Standard Milling Condition



- 切削时以左图的条件为基准
- 请使用刚性好、精度高的机械设备
- 请选择合适的切削液
- 使用的设备不能提高转速时，要将进给速度和转速按相同的比例下调
- 铣刀装夹时，刃部的径向跳动必须在 0.01mm 以下

工件材料 Work Material	高硬度钢 (40 ~ 55HRC)				高硬度钢 (55 ~ 60HRC)				高硬度钢 (60 ~ 65HRC)			
	进给速度 (mm/min) Feed rate		回转速度 (min ⁻¹) Revolution		进给速度 (mm/min) Feed rate		回转速度 (min ⁻¹) Revolution		进给速度 (mm/min) Feed rate		回转速度 (min ⁻¹) Revolution	
	标准	高速	标准	高速	标准	高速	标准	高速	标准	高速	标准	高速
0.2	320	-	25000	-	300	-	25000	-	270	-	25000	-
0.3	520	-	25000	-	480	-	25000	-	390	-	25000	-
0.4	730	-	25000	-	590	-	21900	-	450	-	19100	-
0.5	1120	1320	23850	25000	710	1150	17500	25000	560	970	15300	25000
0.75	1150	2400	15900	25000	720	1850	11650	25000	730	1370	10200	19100
1	870	1830	11950	21500	540	1310	8750	18300	500	970	7650	14300
1.5	860	1710	7950	14300	540	1280	5850	1200	470	940	5100	9550
2	800	1640	5950	10750	510	1250	4400	9150	460	910	3800	7150
2.5	770	1810	4750	8600	490	1300	3500	7300	420	950	3050	5750
3	700	1430	4000	7150	440	1100	2900	6100	420	830	2550	4750
4	620	1350	3000	5350	400	1050	2200	4600	380	780	1900	3600
5	560	1260	2400	4300	350	950	1750	3650	350	720	1550	2850
6	500	1170	2000	3600	300	830	1450	3050	310	640	1250	2400
加工内容 Processing	Ad		Pf		Ad		Pf		Ad		Pf	
粗加工	≤0.1D	≤0.08D	≤0.3D	≤0.24D	≤0.07D	≤0.05D	≤0.21D	≤0.15D	≤0.07D	≤0.05D	≤0.21D	≤0.15D
精加工	≤0.03D	≤0.02D	≤0.1D	≤0.05D	≤0.02D	≤0.01D	≤0.05D	≤0.05D	≤0.02D	≤0.01D	≤0.05D	≤0.05D